



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5549-1

Job Sheet 170784



Part No: D5549-1

Job Qty: 2 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 3/2/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D5549 REV.B SHEETS 5, 6 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Waterjet		18/01/24
100	Waterjet	2 pcs	3/1/18	3/1/18	0.00	4.37	Waterjet1		18/01/24
110	QC	2 pcs	3/1/18	3/1/18	0.00	0.00	QC2 Waterjet-4		18/01/24
120	CNC Vertical Machining	2 pcs	3/1/18	3/1/18	0.00	3.36	HAAS1-4		18/4/10/5C-L
130	QC	2 pcs	3/1/18	3/1/18	0.00	0.00	QC2 Machining-4		18-04-12
140	QC	2 pcs	3/1/18	3/1/18	0.00	0.00	QC8 Machining-4		18-04-16
150	HandFinish	2 pcs	3/1/18	3/1/18	0.00	0.97	HandFinish1		18-04-17
160	QC	2 pcs	3/1/18	3/1/18	0.00	0.00	QC7-5		18-04-17
170	Powdercoat	2 pcs	3/2/18	3/2/18	0.00	0.22	Powdercoat1		18-04-17
180	QC	2 pcs	3/2/18	3/2/18	0.00	0.00	QC3		APR 23 2018
190	Packaging	2 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2		APR 23 2018
200	QC21-SA	2 Ea	3/2/18	3/2/18	0.00	0.00	QC21		APR 23 2018

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 120 - Drill holes as per dwg manually on Hass4 Dwg rev: 3:05
170 ***Mask holes or blow out access powdercoat in holes*** START TIME: 2:55 OVEN TEMPERATURE:
320 FINISH TIME: 1:45 11/3/18
2:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	9.2000 ft (4.6 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Job No: 170784 Operation 01/24/18	DISPOSITION Fwd Beam S035155 PART NO: D5549-1 Original Serial #: S035155 Revision: Operation: Change No:	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> QTY Effective : _____ MRB (QSI042) Approval Disposition Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	AGAINST DEPARTMENT/PROCESS				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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DART AEROSPACE LTD		Work Order:	170784
Description: FWD BEAM		Part Number:	DSS40-1
Inspection Dwg: 5549	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.05	+/- .030	1.05	✓		Vicor-02	
3.00	+/- .030	3.00	✓		4-pr	
6.50	+/- .030	6.50	✓			
4.05	+/- .030	4.05	✓			
19.41	+/- .030	19.41	✓			
34.55	+/- .030	34.55	✓			
47.03	+/- .030	47.03	✓			
52.08	+/- .030	52.08	✓			
53.36	+/- .030	53.36	✓			
.65	+ .030 - .000	.651	✓			
.50	+ .030 - .000	.507	✓			
3.00	+/- .030	2.996	✓			
47.250"	± 0.015"	47.250"	✓		Readout	Precisionmaster / Edge Finder
Ø 0.377"	+0.006"/-0.001	0.378"	✓		Vernier	CNC-19
Ø 0.257"	+ " / - "	0.257"	✓		"	" "
Ø 0.377"	+0.002"/-0	0.3775"	✓		Gage Pin	
1.30"	± 0.030"	1.298"	✓		Vernier	CNC-19
1.500"	± 0.010"	1.498"/1.500"	✓		"	" "
2.300"	"	2.298"	✓		"	" "
0.60"	± 0.030"	0.592"	✓		"	" "
3.36"	"	3.360"	✓		"	" "
Ø 2.50"	± 0.010"	2.498"	✓		"	" "
4.500"	"	4.498/4.500"	✓		"	" "

Measured by: <i>ae</i> 18/4/12	Audited by: <i>DAS</i> 20 9-89	Preliminary Approval:
Date: 18/01/24	Date: 18-04-12	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

